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CLAIMS

1. Intake manifold (1) comprising a chamber, several intake pipes (2) in the form of duct portions connecting the manifold chamber with the heads and a device for regulating flow in said intake pipes comprising at least a control shaft (4) and valves (3) supported by said control shaft (4), said flow regulation device being integrated into the structure of manifold (1) and being rotatably mounted into bearings (6), said manifold (1) consisting of at least two complementary parts (1'', 1''') joined one to the other, characterized in that the two parts (1'', 1''') form complementary portions at least of said chamber, the bearings (6) being formed onto at least one of said parts (1'', 1''') in an assembly area of said parts (2', 2'' or 1'', 1''') outside said intake pipes (2).

2. Manifold according to claim 1, characterized in that said bearings (6) are obtained by assembling said two complementary parts (1'', 1''').

3. Manifold according to claim 2, characterized in that the control shaft (4) is fixed and positioned by elastically inserting said shaft (4) into said bearings (6, 12).

4. Manifold according to any of the claims 1 to 3, characterized in that said bearings (6) are formed onto one (1'') of said parts, said shaft (4) being blocked between said parts (1'', 1''') without any contact with the other one (1''') of said two parts (1'', 1'''), the other part (1''') preventing the shaft (4) from coming out of said bearings (6) after the assembly of the two parts (1'' and 1''').

5. Manifold according to any of the claims 1 and 2, characterized in that the control shaft (4) is "sandwiched" between the parts (1'', 1''') constituting said manifold (1) in the assembly and connection area of said parts (1'', 1''').

6. Manifold according to any of the claims 1, 2 and 5, characterized in that said bearings (7) are sealed by interposing a sealing element (8).

7. Manifold according to any of the claims 1 to 6, characterized in that the control shaft (4) comprises at least a cylinder-shaped protuberance (9') cooperating with translation blocking stops (10) of said control shaft (4).

8. Manifold according to any of the claims 1 to 7, characterized in that said two complementary parts are made of thermoplastic material and are assembled by vibration welding.

9. Manifold according to any of the claims 1 to 8, characterized in that said regulation device is provided on one of its ends with a rotation coupling element connected with an actuator (14').

10. Manifold according to any of the claims 7 to 9, characterized in that said regulation device extends transversally near one of the ends of the intake pipes (2) in the connection area of said intake pipes (2) with a wall (1') of the chamber of manifold (1), said bearings (6, 7 12) and said translation blocking stops (10) of the control shaft (4) being formed onto said wall (1') of the chamber of manifold (1).

11. Manifold according to any of the claims 7 to 9, characterized in that said regulation device extends near one of the ends of the intake pipes (2) in the area where said manifold (1) is fixed onto the heads.

12. Intake manifold according to claim 10, characterized in that the assembly of the parts (1", 1'') constituting manifold (1) results in a sealed case (15) around the connection areas of the assembly of said intake pipes (2) with the wall (1') of manifold (1).

13. Intake manifold according to claim 12,

characterized in that said sealed case (15) is completed in an area of passage (15') for the portion of the control shaft (4) getting out and supporting the rotation coupling element connected with the actuator (14') by means of a ring-shaped axial plug (16) shrink-fitted or tight-fitted or welded into said passage (15').

14. Intake manifold according to claim 12, characterized in that the sealed case (15) formed by assembling the two parts (1" and 1'') of manifold (1) is closed in an area of passage (15') for the rotation coupling element (14) of said control shaft, by interconnection on the outer surface of said two parts (1" and 1''), by vibration welding, by means of a third hollow part (17) closing said rotation coupling element (14) and an axially sealed bearing (6, 12).

15. Intake manifold according to any of the claims 13 and 14, characterized in that the regulation device fully extends within the sealed case (15), said shaft (4) not going across the welding assembly areas or lines, the two valves (3) at the opposite ends of shaft (4) being mounted protrudingly and the valve (3) positioned near passage (15') being provided with an axial blind channel (18) housing by

insertion the end of handling bar (14") constituting said rotation coupling element (14).

16. Method to produce an intake manifold according to any of the claims 1 to 15, starting from at least two parts made of thermoplastic material, characterized in that it consists in providing a first part (1") of an intake manifold (1), in installing on said first part and within portions of suitable supporting or guiding bearings (6, 12), a regulation device comprising a control shaft (4) and a plurality of valves (3) arranged each within a through opening or a part passage (2') of corresponding intake pipe (2), in providing at least a second part (1'') of the intake manifold (1) and in arranging it in assembling position with the first part (1") blocking control shaft (4) with valves (3), and finally in assembling by vibration welding said at least two parts (1", 1'') of intake manifold (1).

17. Method according to claim 16, characterized in that said regulation device is mounted onto said first part (1") and the assembly of the two parts (1" and 1'') results in a sealed case (15) around said assembly except for a drawing passage (15'), the latter being sealed when coupling the rotation coupling element (14) with the control shaft (4).